

Work Order ID **76993*****76993***

Page 1

November-24-11 2:44:38 PM

Item ID: D3294-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 24/11/2011 Start Qty: 20.00

20

Cust Item ID:

Required Date: 08/12/2011 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/11/24 Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3294

Sheet 5-6 rev.C

E 11.11.24

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3294

2024 .000

Dwg Rev: EProg Rev: E

****grain direction as per dwg D3294 ****

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B11-12-12

B11-12-12

57

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 76993

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Page 3

November-24-11 2:44:38 PM

Item ID: D3294-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Doubler
 Start Date: 24/11/2011 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 08/12/2011 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location <u>GA</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

27x M/L 12/01/26

27x d M 12/01/26
count

27x 27x

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Work Order ID 76993***76993***


Page 4

November-24-11 2:44:38 PM

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Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 24/11/2011 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 08/12/2011 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/1/30 

PL 1201-27.
(27)

W/O:		WORK ORDER CHANGES					
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Picklist Print

November-24-11 2:44:42 PM

Page 1

Work Order ID: 76993

76993

Parent Item: D3294-5

D3294-5

Parent Item Name: Doubler

Start Date: 24/11/2011

Required Date: 08/12/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	204.3000	0.065	1.368421	2		

M2024T3S 080

2024-T3 .080 sheet

**

B11-12-12

Location

Loc Qty

Loc Code

MAT022

204.3

105411

6

109424

4

110347

0.5

112331

3

113796

7

114025

15.7

116604

5.8

117392

40.1

118180

49.7

119117

72.5

117 392

27

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	76993
Description: Doubler		Part Number:	D3294-5
Inspection Dwg: D3294 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.130	✓		✓ .1302	
0.65	+/-0.030	.653	✓		✓	
0.30	+/-0.030	.301	✓		✓	
0.53	+/-0.030	.53	✓		✓	
3.36	+/-0.030	3.368	✓		✓	
2.50	+/-0.030	2.494	✓		✓	
0.15	+/-0.030	.151	✓		✓	
9.21	+/-0.030	9.217	✓		Prox 502	
0.400	+/-0.010	.401	✓		✓	
0.300	+/-0.010	.300	✓		✓	
0.30	+/-0.030	.303	✓		✓	
0.625	+/-0.010	.626	✓		✓	
0.080	+/-0.010	.081	✓		✓	
1.00	+/-0.030	1.007	✓		✓	

Measured by:	RB
Date:	11-12-17

Audited by:	S
Date:	11/12/17

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

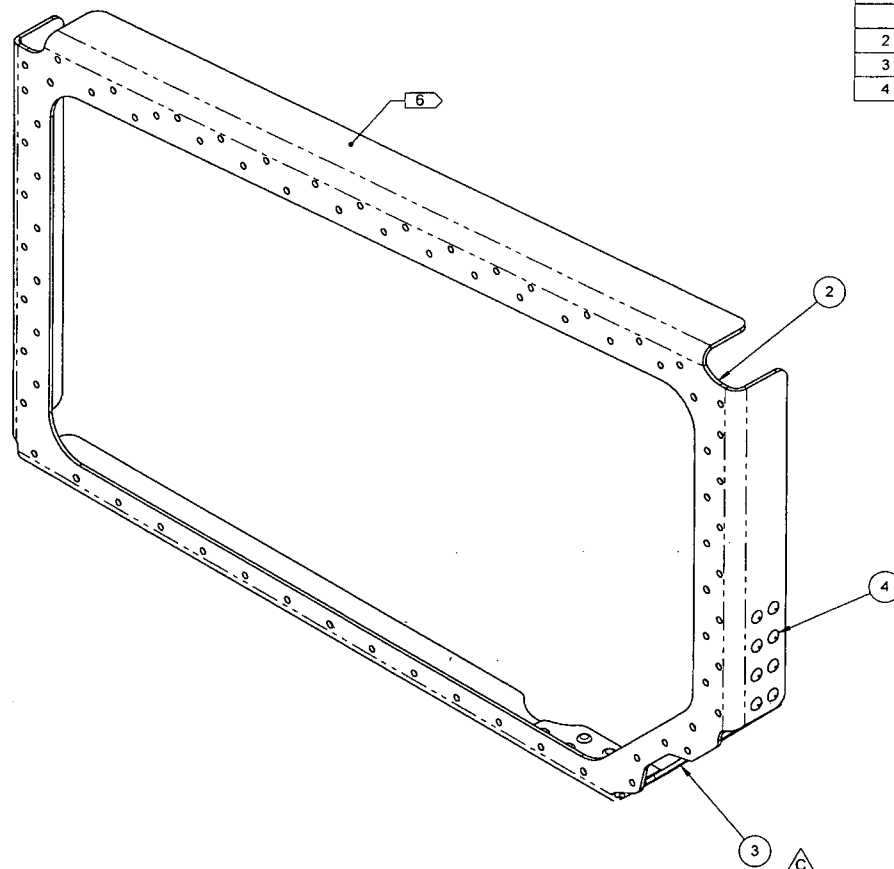
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ITEM NO.	QTY. -1	PART NUMBER	DESCRIPTION
1	X	D3294-1	BRACKET ASSEMBLY
2	1	D3294-3	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET



D3294-1 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 76953 M.C.J
11/11/25

RELEASED
09/03/24

C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6.	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.24		

DART AEROSPACE LTD
HA'VKEBURY, ONTARIO, CANADA

DRAWING NO. **D3294** REV. C
SHEET 1 OF 6
TITLE **BRACKET** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

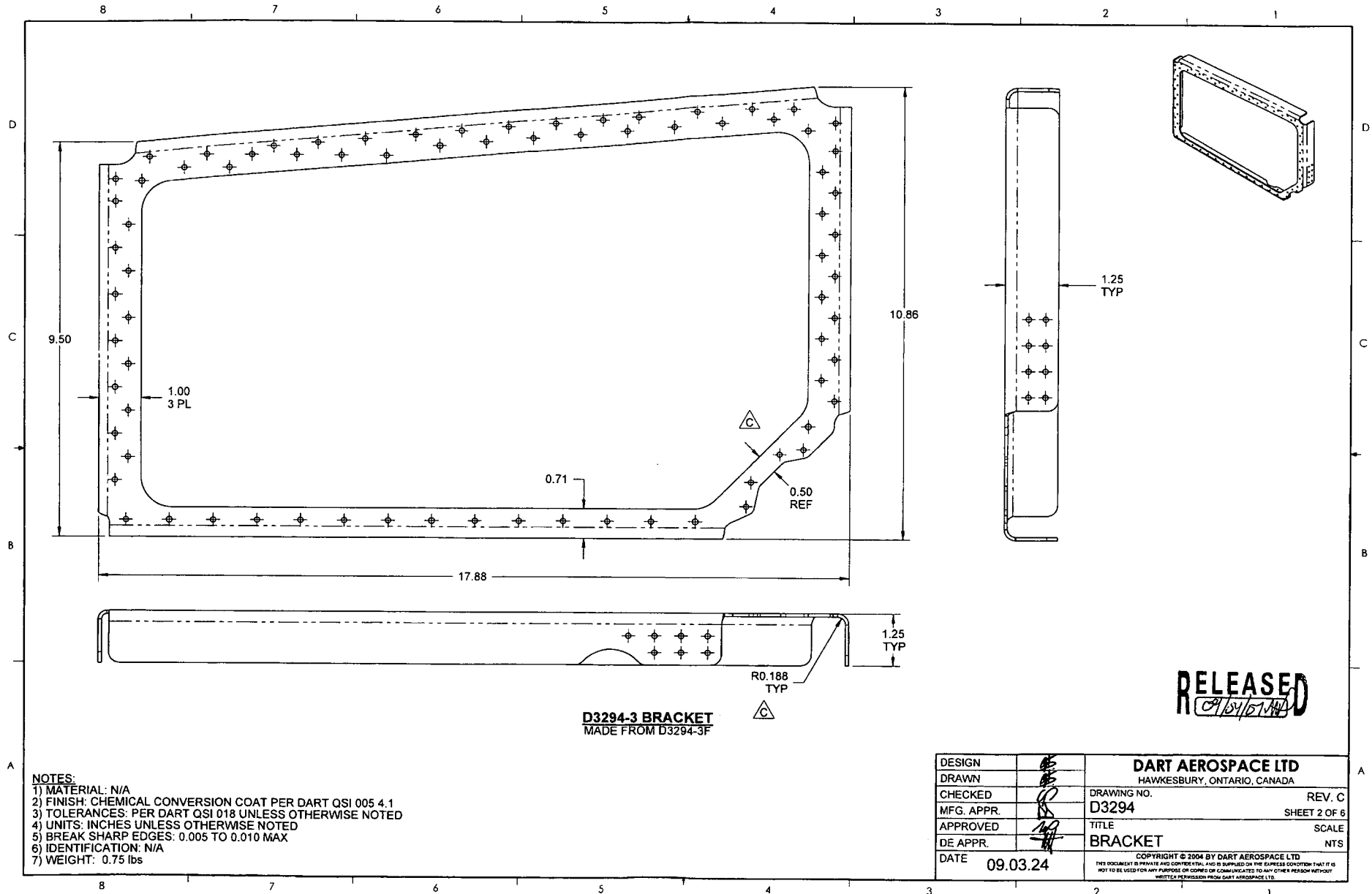
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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76993



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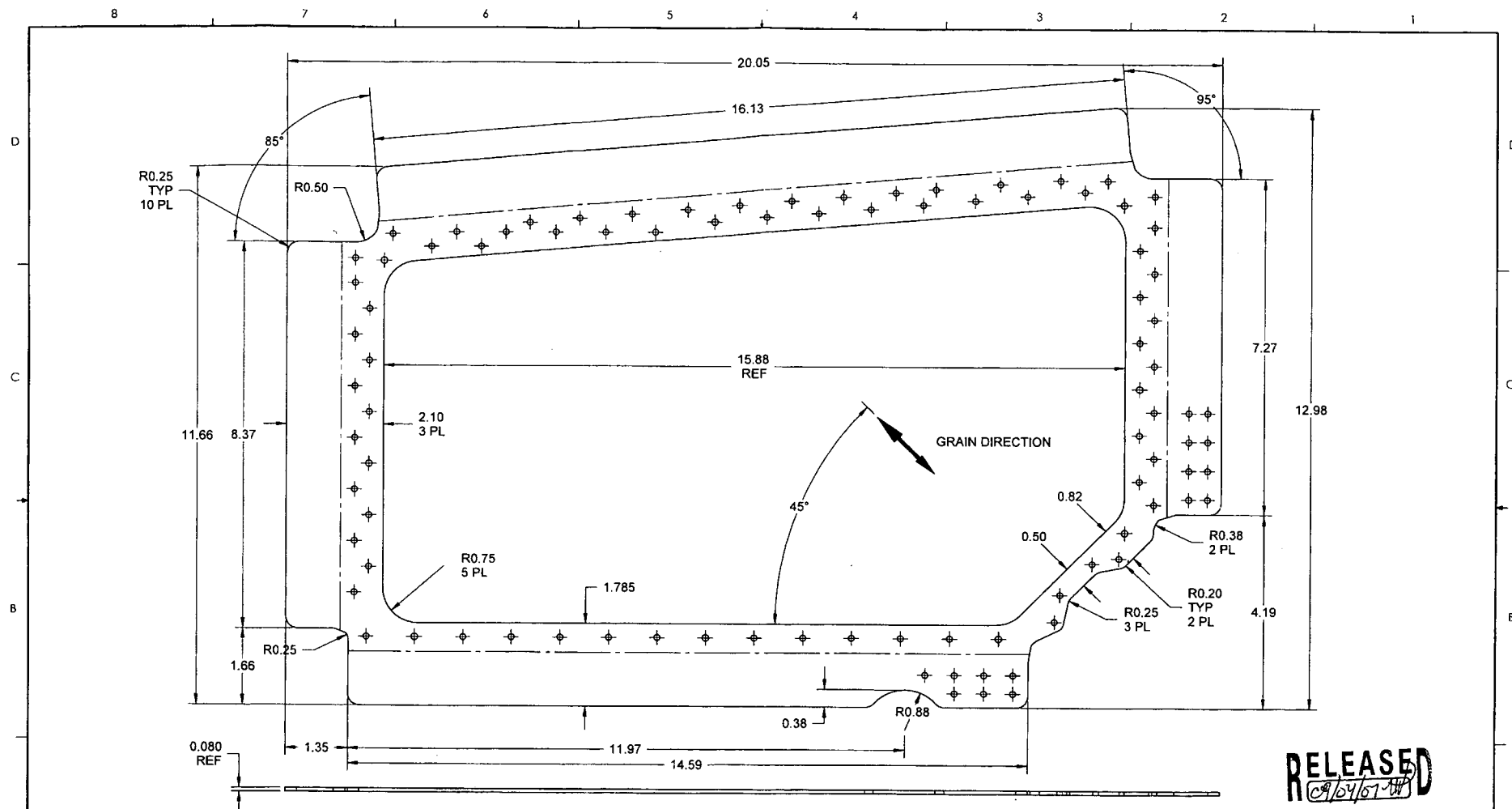
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NOTE: Date & initial all entries

76993



D3294-3F BRACKET FLAT PATTERN

RELEASED
C9/04/07-10

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO. D3294	REV. C
MFG. APPR.	AS	SHEET 3 OF 6	
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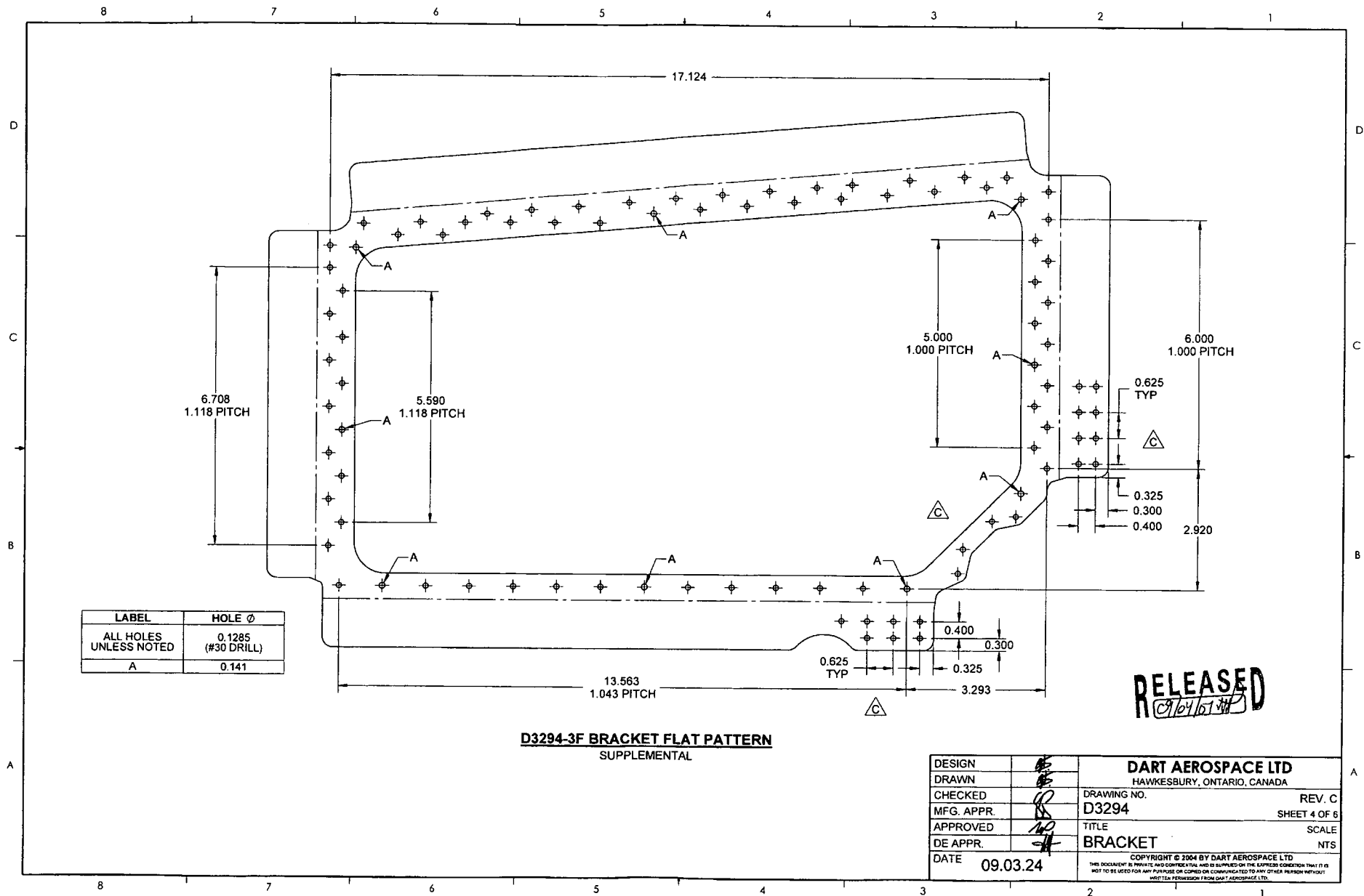
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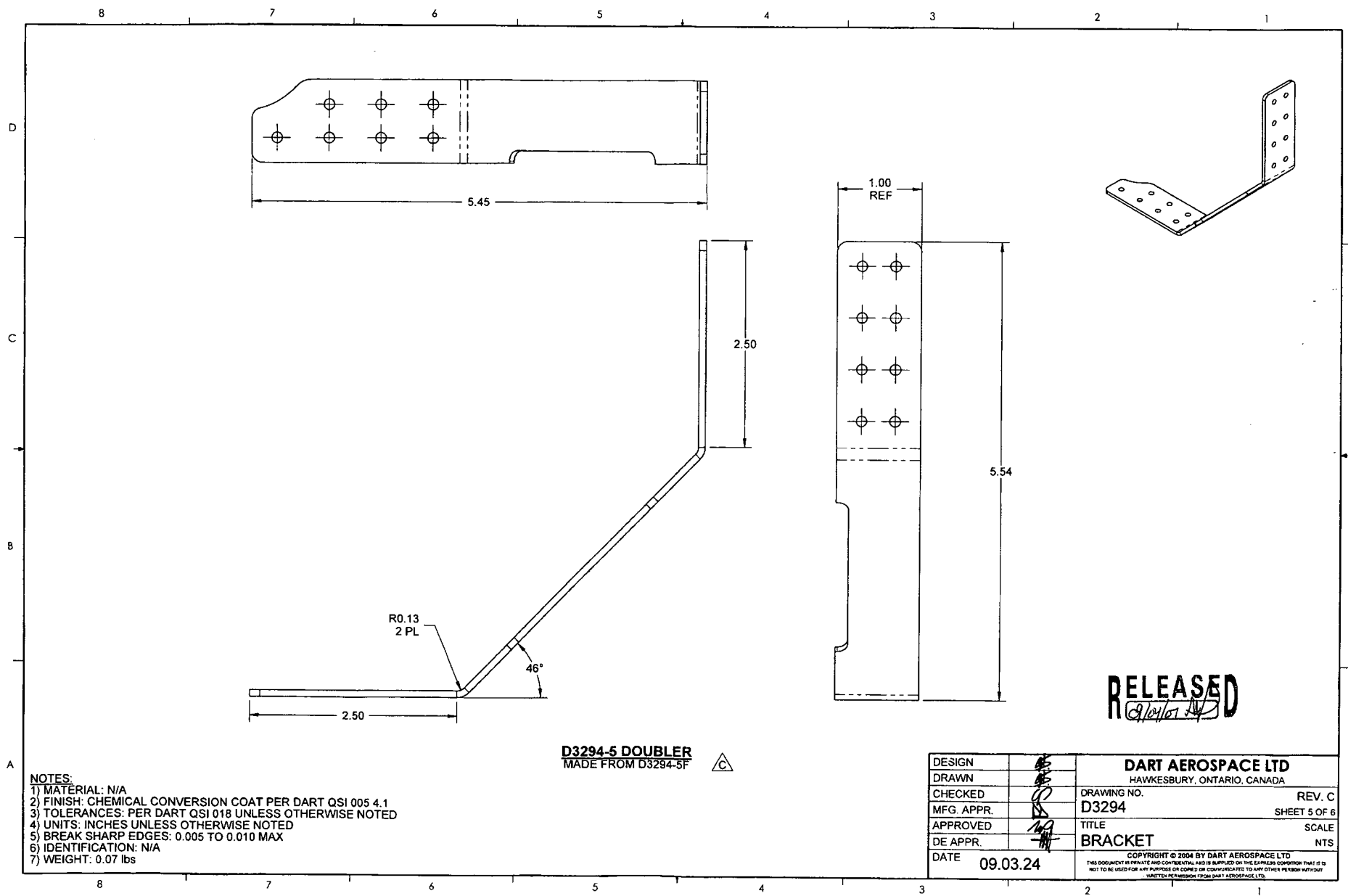
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NOTE: Date & initial all entries

76993



RELEASED
9/10/01

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3294	REV. C
MFG. APPR.		SHEET 5 OF 6	
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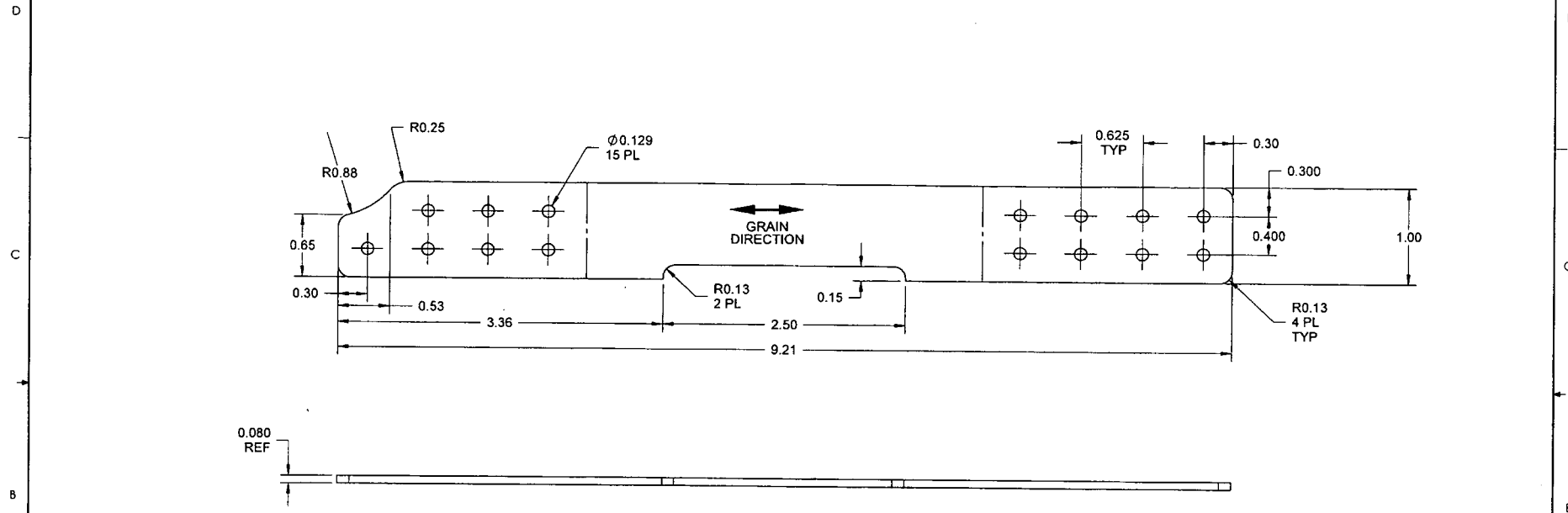
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A number line from 0 to 8. The line is divided into 8 equal segments by tick marks. The numbers 2, 3, 4, 5, 6, and 7 are written above the tick marks. The segment between 0 and 1 is shaded gray.



△C

09/04/07

T) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4
OR AMS 4037 (REF DART SPEC M2024T3S.080)

- 7) WEIGHT: 0.07 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3294	SHEET 6 OF 6
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